

Work Order ID 57426

April 6, 2010 4:00:17 PM



Page 1

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly (Basket Lid, LH)				Stop	
Start Date:	06/04/2010	Start Qty:	2.00			
Required Date:	12/04/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10-4-06	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	Rev A								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836								
	2- remove identification markings								
	3- deburr								
	4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836								
	5- weld D2327-3 spacer bushing as per dwg D3836 A/R ER316 S.S. Rod Batch: 111679								
	6- grind weld flush where indicated on dwg								
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

2 10-04-12

SAN 10-04-07

② PD 10.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57426

April 6, 2010 4:00:17 PM



Page 2

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/04/13

② 10/04/13

42

64

150

Identify as per dwg & Stock Location:

0.00



Packaging

Basket cell
Memo

0.00

Packaging

10/04/13 ②

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/14

BS 10-4-13
②

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 4:00:21 PM

Page 1

Work Order ID: 57426

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC


Start Date: 06/04/2010

Required Date: 12/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3  Spacer Bushing		Manufactured	No			100	Each	31.0000	2.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Cpl 10-04-12

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

31

55917

11

57186

20

2

M304TS0.750W.065

Purchased

No

100

f

562.8397

3.7491



304 SQ Tube .75x.75x.065W

SAN 10-04-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

562.8397

111148

58

113956

23.5

114137

481.3397

3.7491

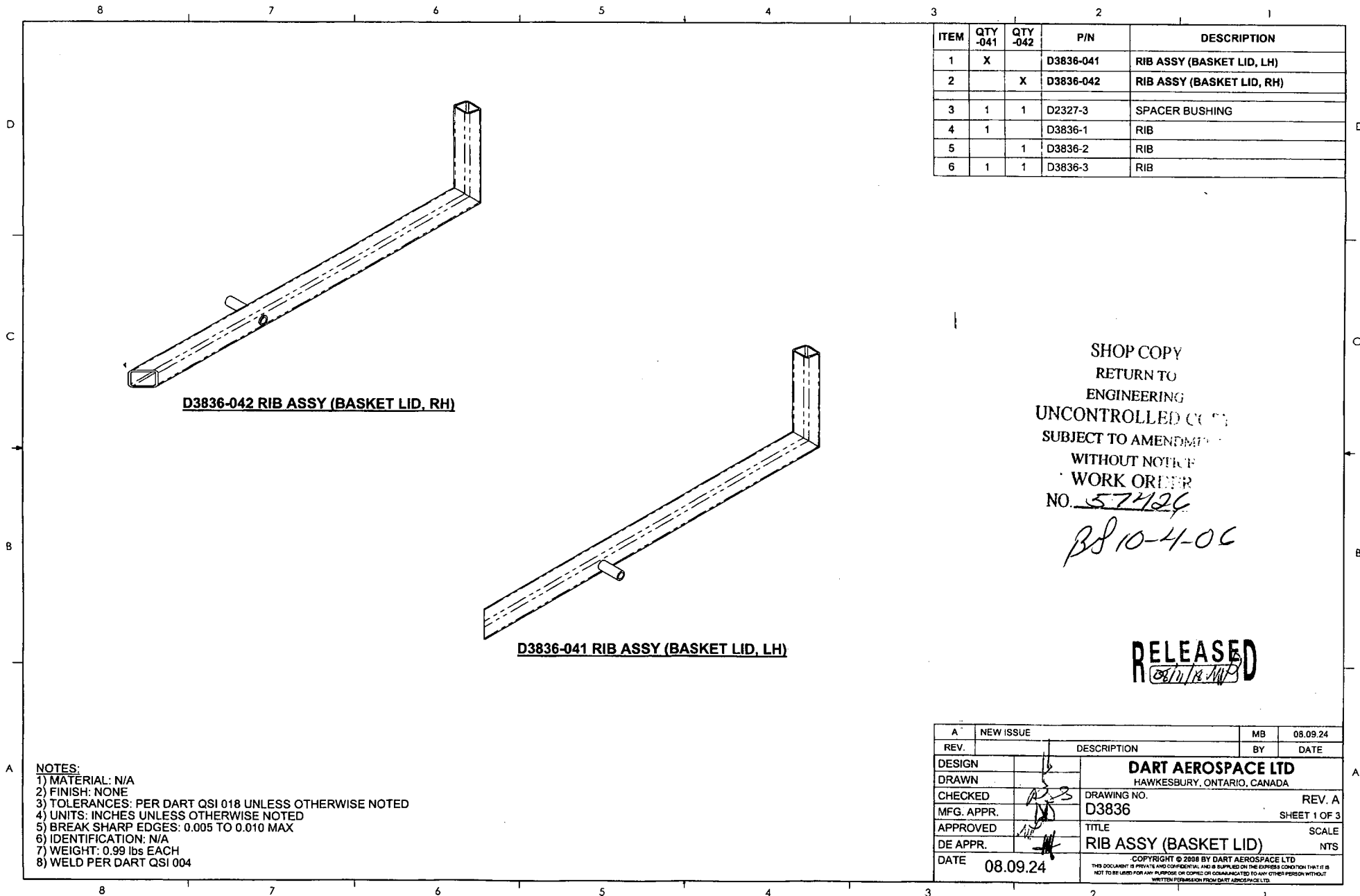
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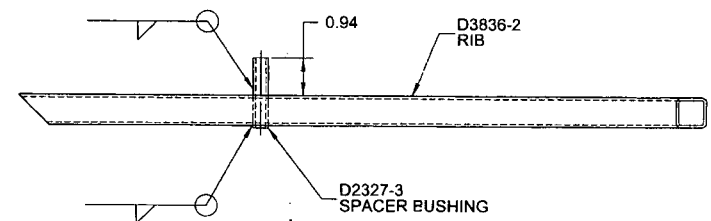
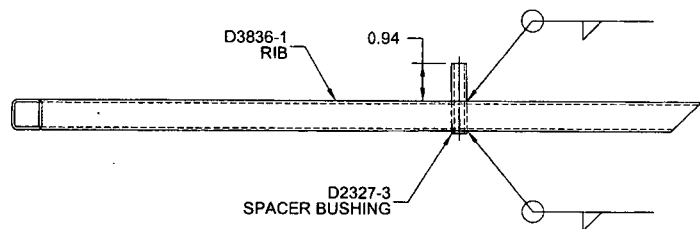
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

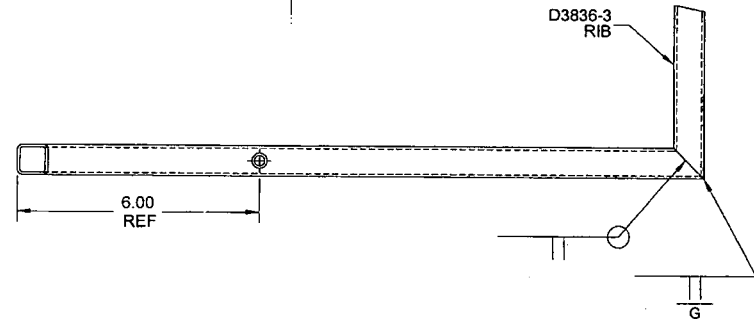
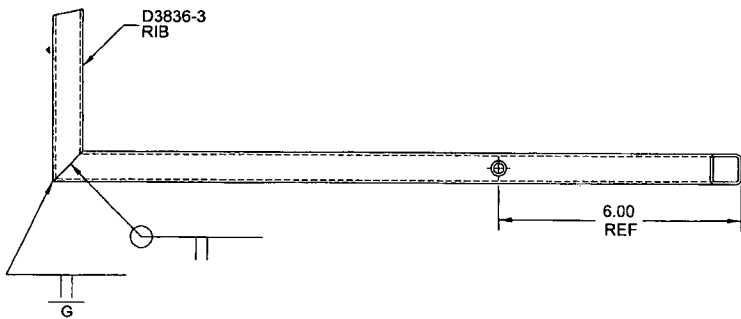
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

w/o 57426

RELEASED
08/11/18 M.H.

A

A

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3836
MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 2 OF 3
DE APPR.	<i>[Signature]</i>	TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS
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8 7 6 5 4 3 2 1

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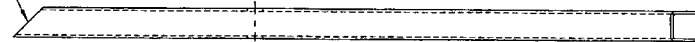
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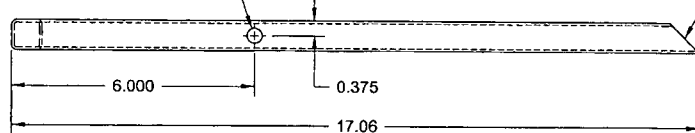
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0.75 X 45°
CHAMFER

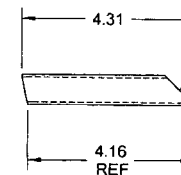


$\phi 0.375^{+0.020}_{-0.000}$ THRU



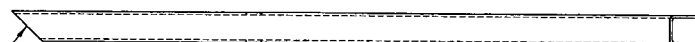
D3836-1 RIB

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CHAMFER

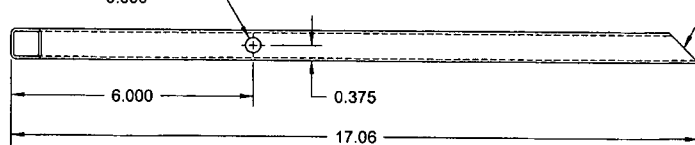


D3836-3 RIB

0.75 X 45°
CHAMFER

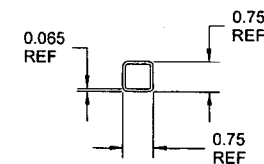


$\phi 0.375^{+0.020}_{-0.000}$ THRU



D3836-2 RIB

0.75 X 45°
CHAMFER



**TYPICAL SECTION
VIEW**

w/o 57424

RELEASED
08/11/08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SCALE NTS
APPROVED			
DE APPR.			
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